

Date: Thursday, 3/8/2007 1:17:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY RH
Job Number	: 31121B		
Estimate Number	: 12596		
P.O. Number	:	Part Number	: D31882M
This Issue	: 3/8/2007 S.O. No. :	Drawing Number	: D3188 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 31086B	Material	:
Written By	:	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.03.08</u>		
Comment	: Est Rev:A New issue ecn882 06-11-30 EC est rev B rev D dwg 07.03.07 ec		

Additional Product

Job Number:



See 3091

Seq. #:	Machine Or Operation:	Description :
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1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8 D2213 Spacer Batch: _____

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
 Issue P/O: _____
 Description: D3188-2M BODY
 SHIP: D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

3.0	D31882P	Spacepod Body
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:17:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 31121B

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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07.02.27

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
JB	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 11
JB	CE	D3188	SCALE
DATE		TITLE	NTS
07.02.22		SPACEPOD BODY	
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLESFOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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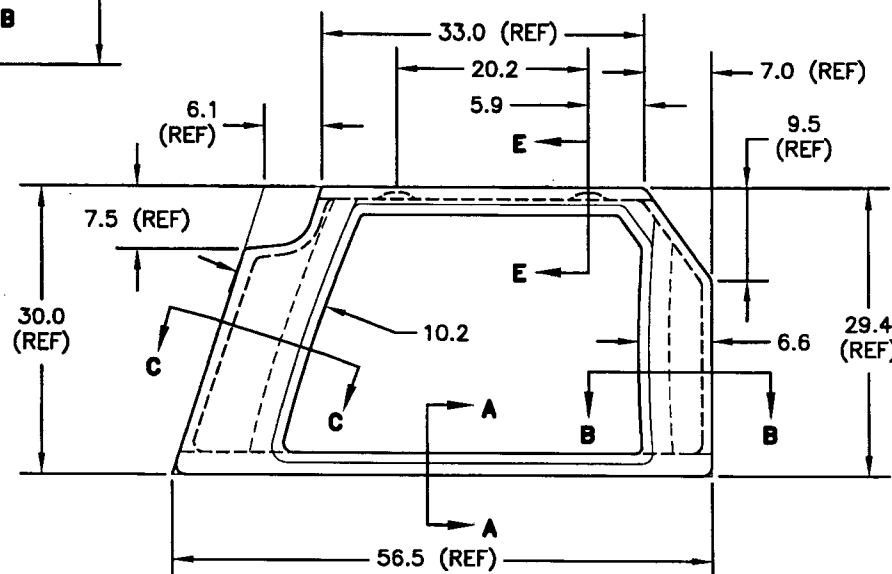
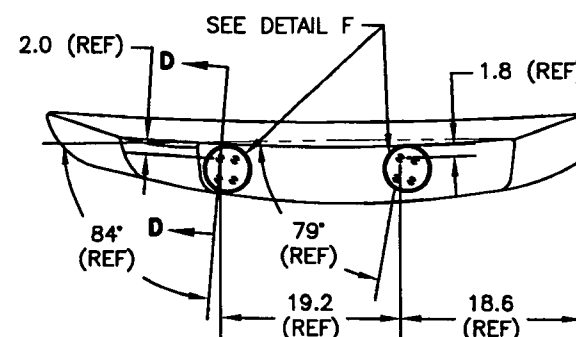
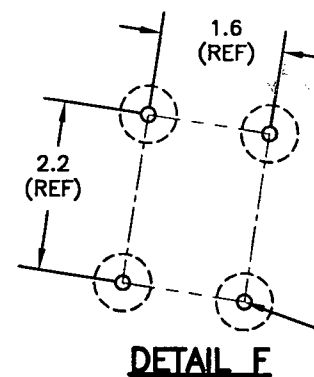
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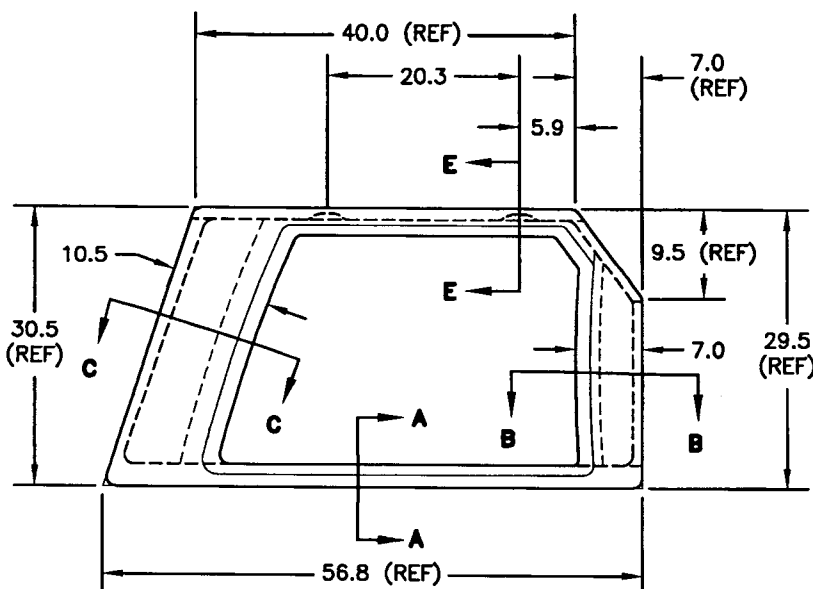
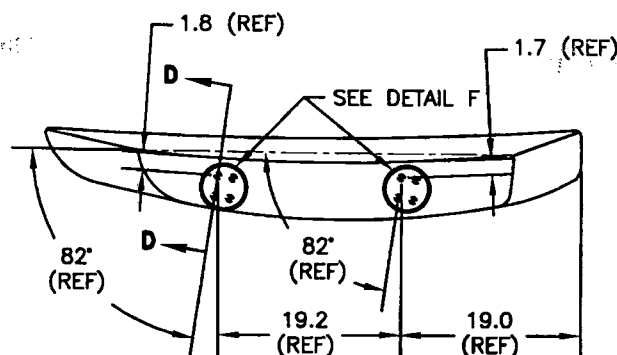


RELEASED
07.02.22

INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-3M SPACEPOD BODY



D3188-1M SPACEPOD BODY

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DATE	07.02.22	TITLE	D3188	REV. D
			SPACEPOD BODY	SHEET 2 OF 11
				SCALE
				NTS

D3186-1M/-3M NOTES:

1. REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2. SEE SHEET #4 FOR SECTION VIEWS.

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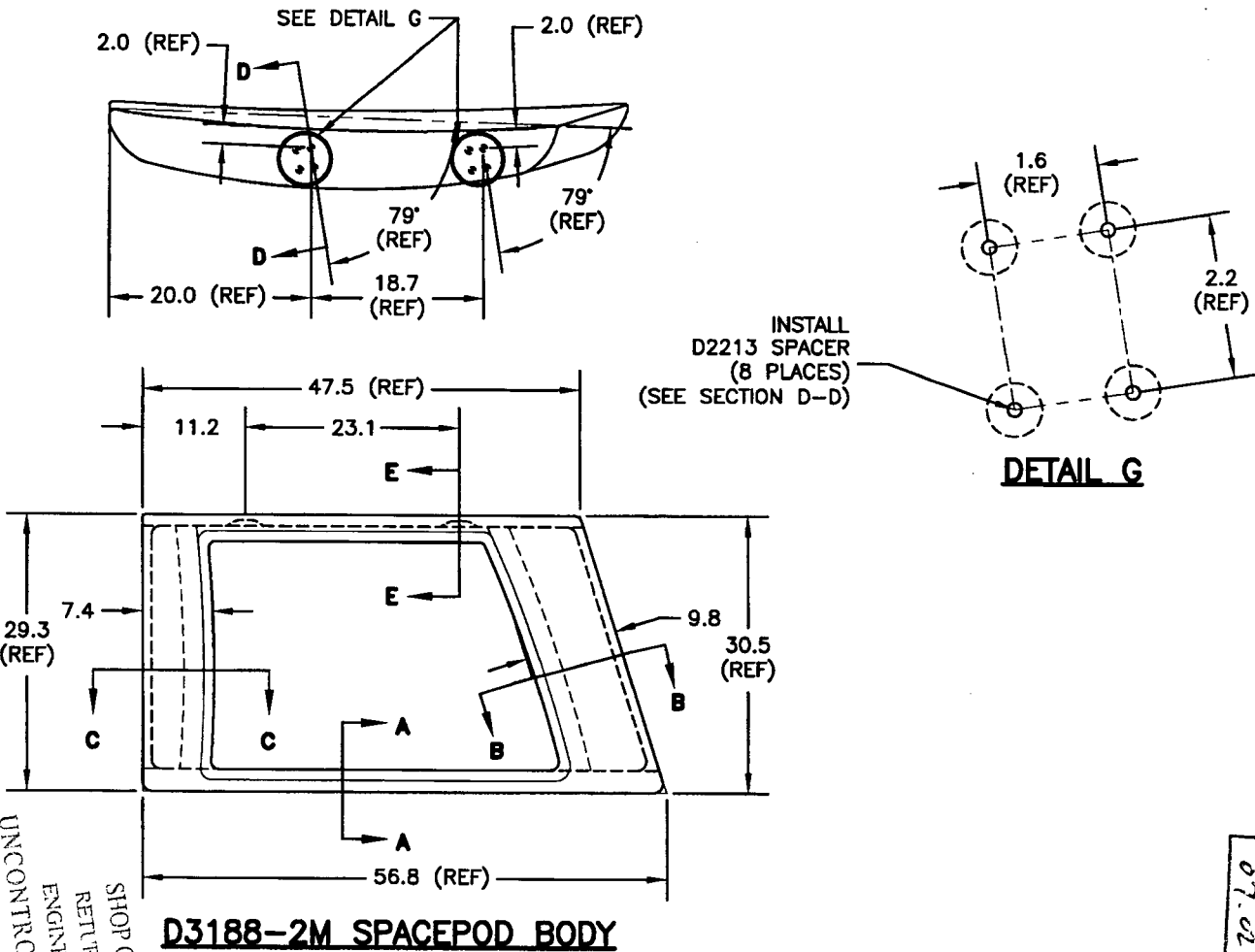
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DATE	07.02.22			
TITLE				DRAWING NO. D3188 REV. D SHEET 3 OF 11
SPACEPOD BODY				SCALE NTS

07.02.27



D3188-2M SPACEPOD BODY

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D3186-2M NOTES:

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2. SEE SHEET #4 FOR SECTION VIEWS.

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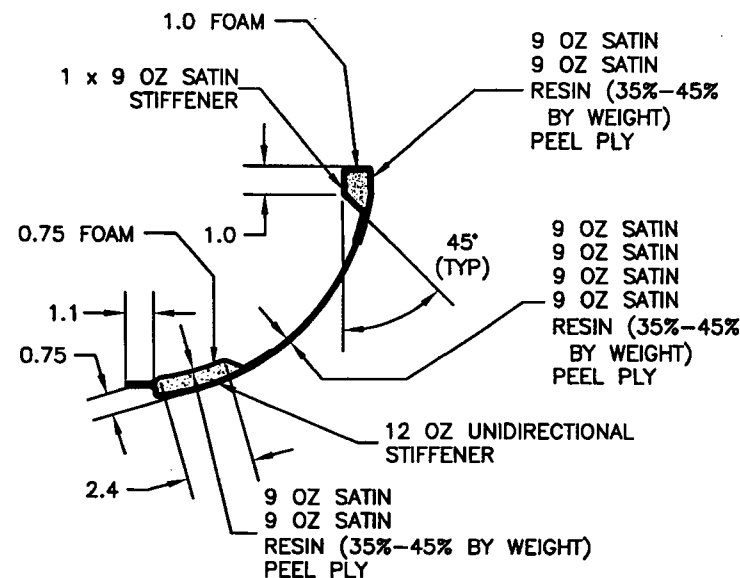
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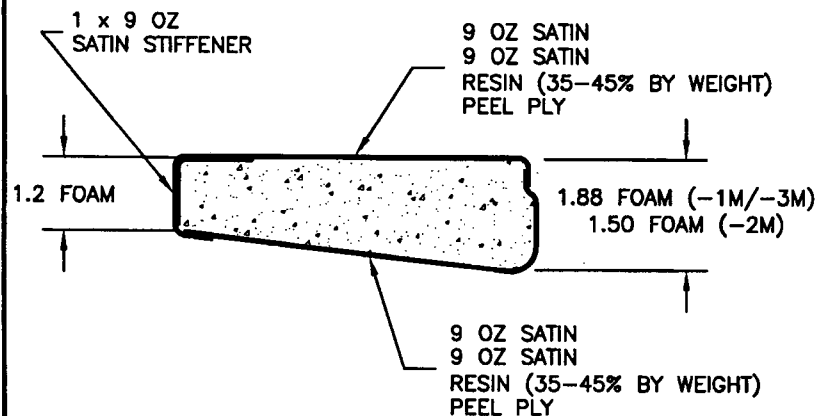
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			SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

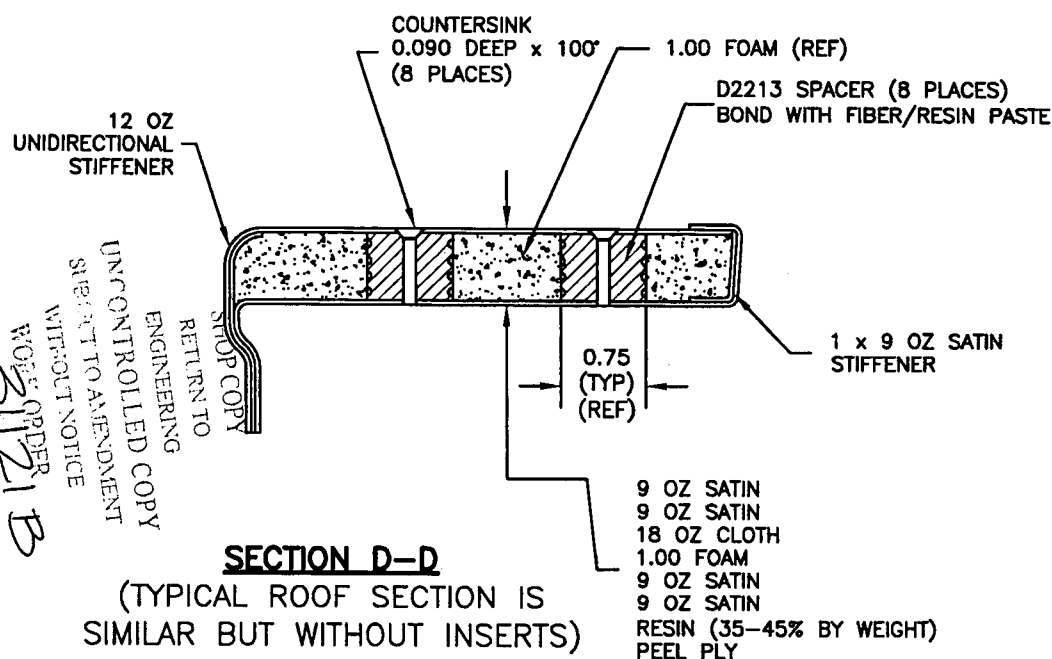
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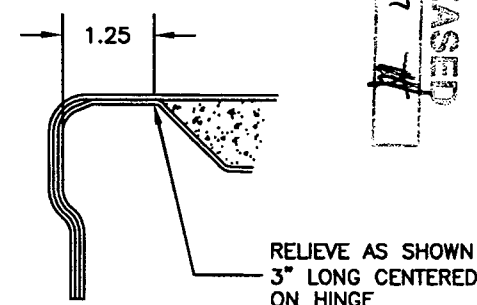
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



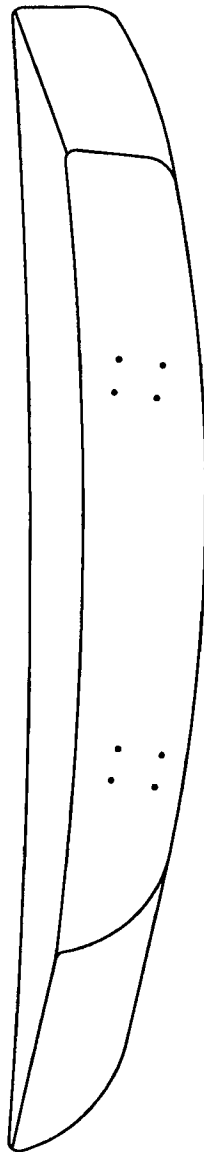
SECTION E-E
(2 PLACES PER POD)

DART

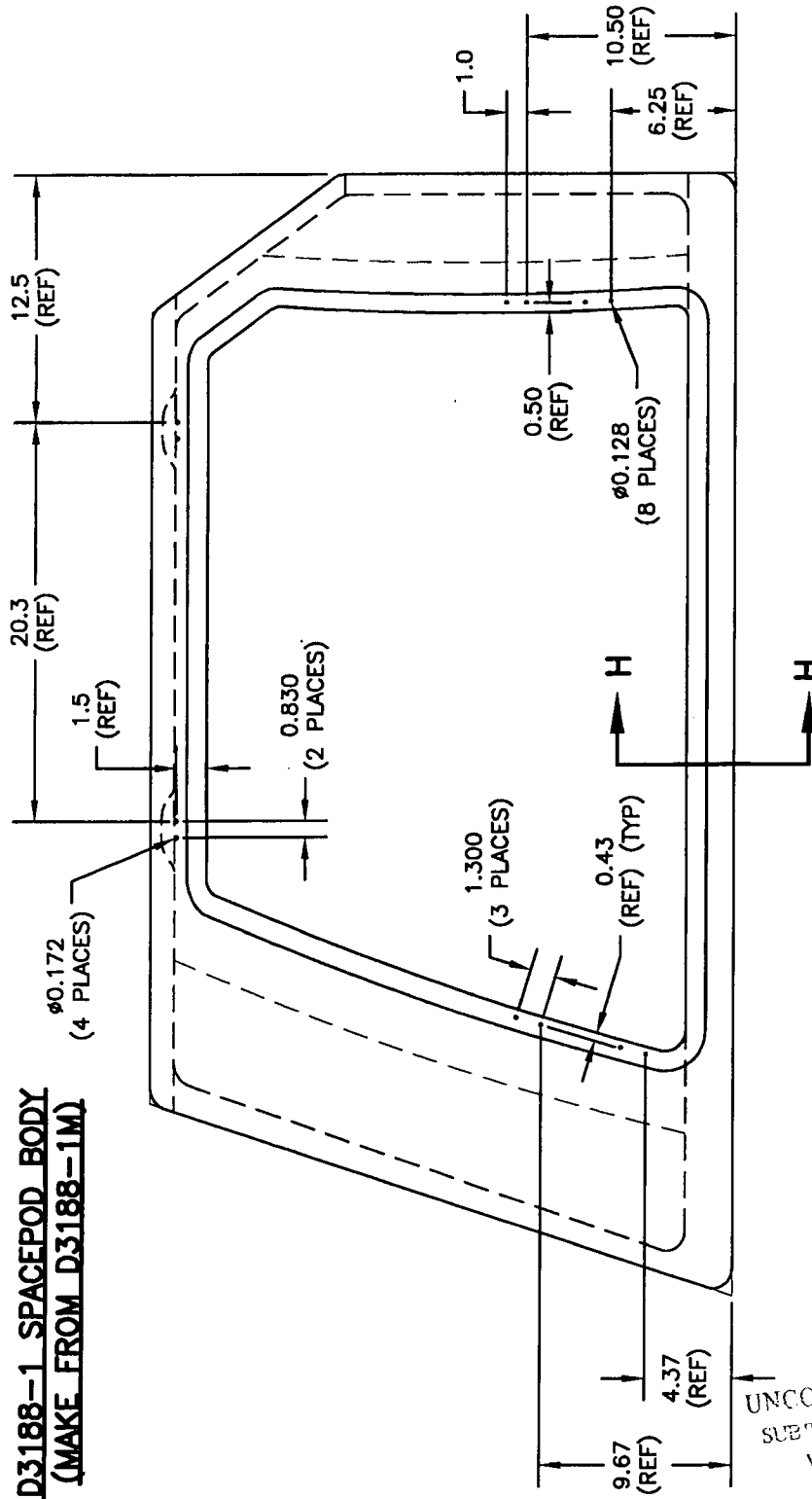
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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07-02-27 *[Signature]*



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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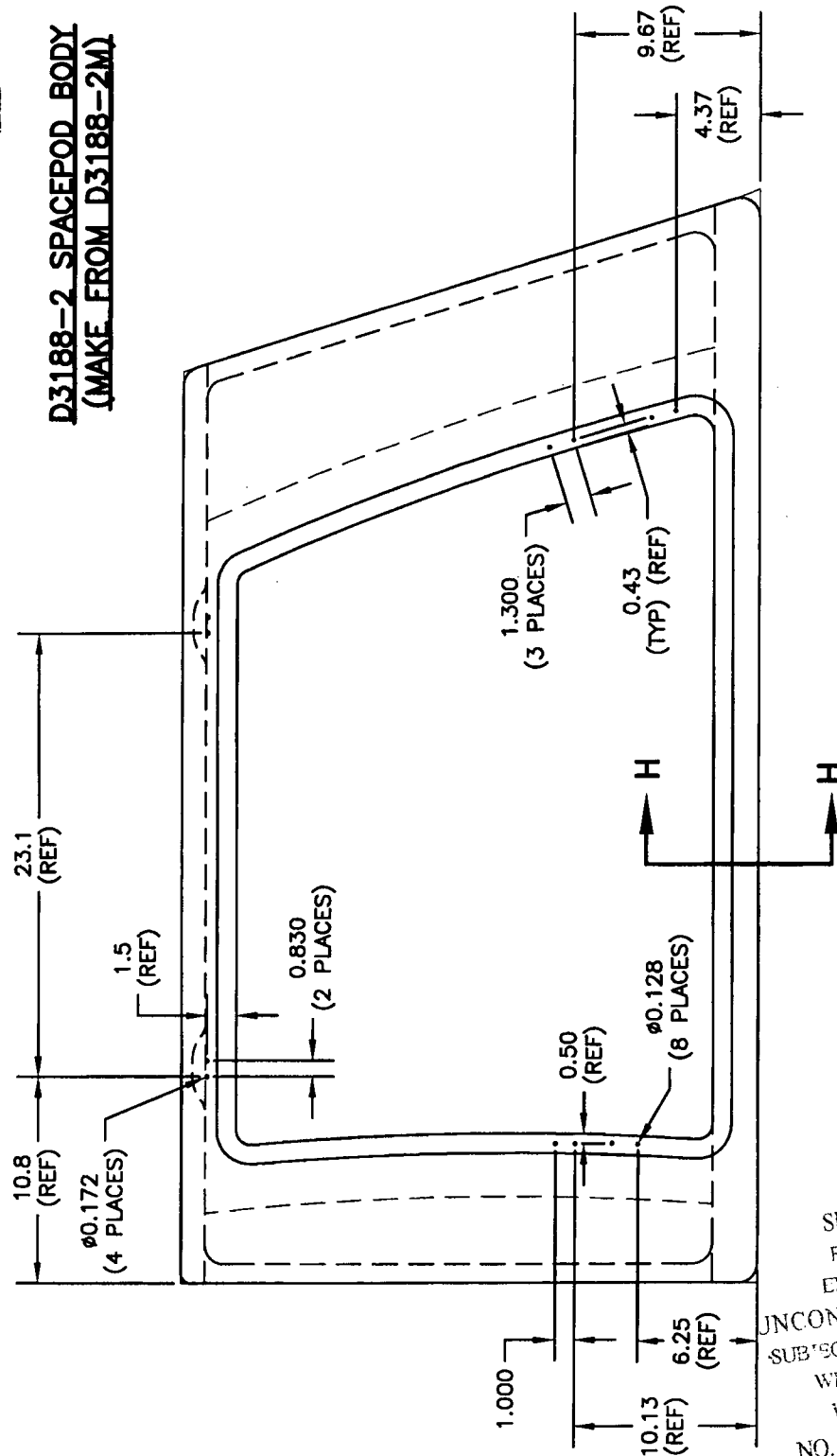
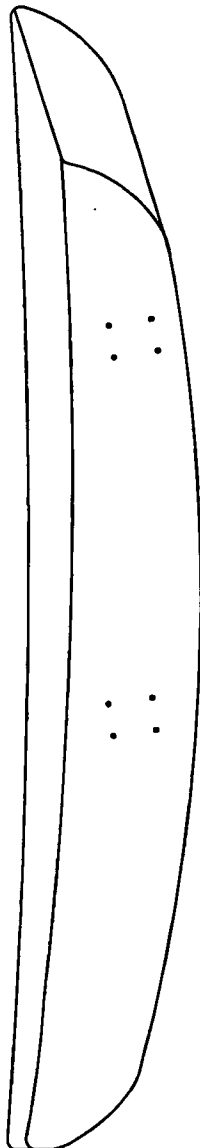
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**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



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- REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
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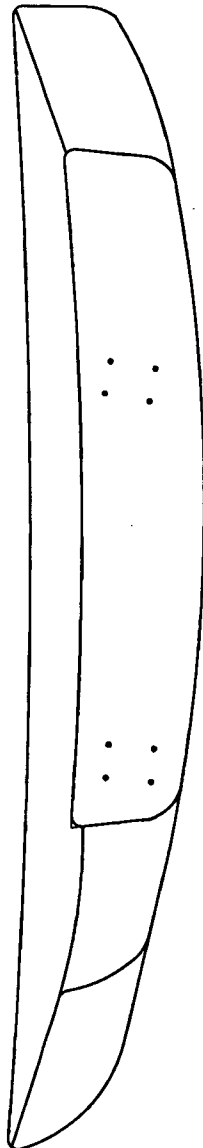
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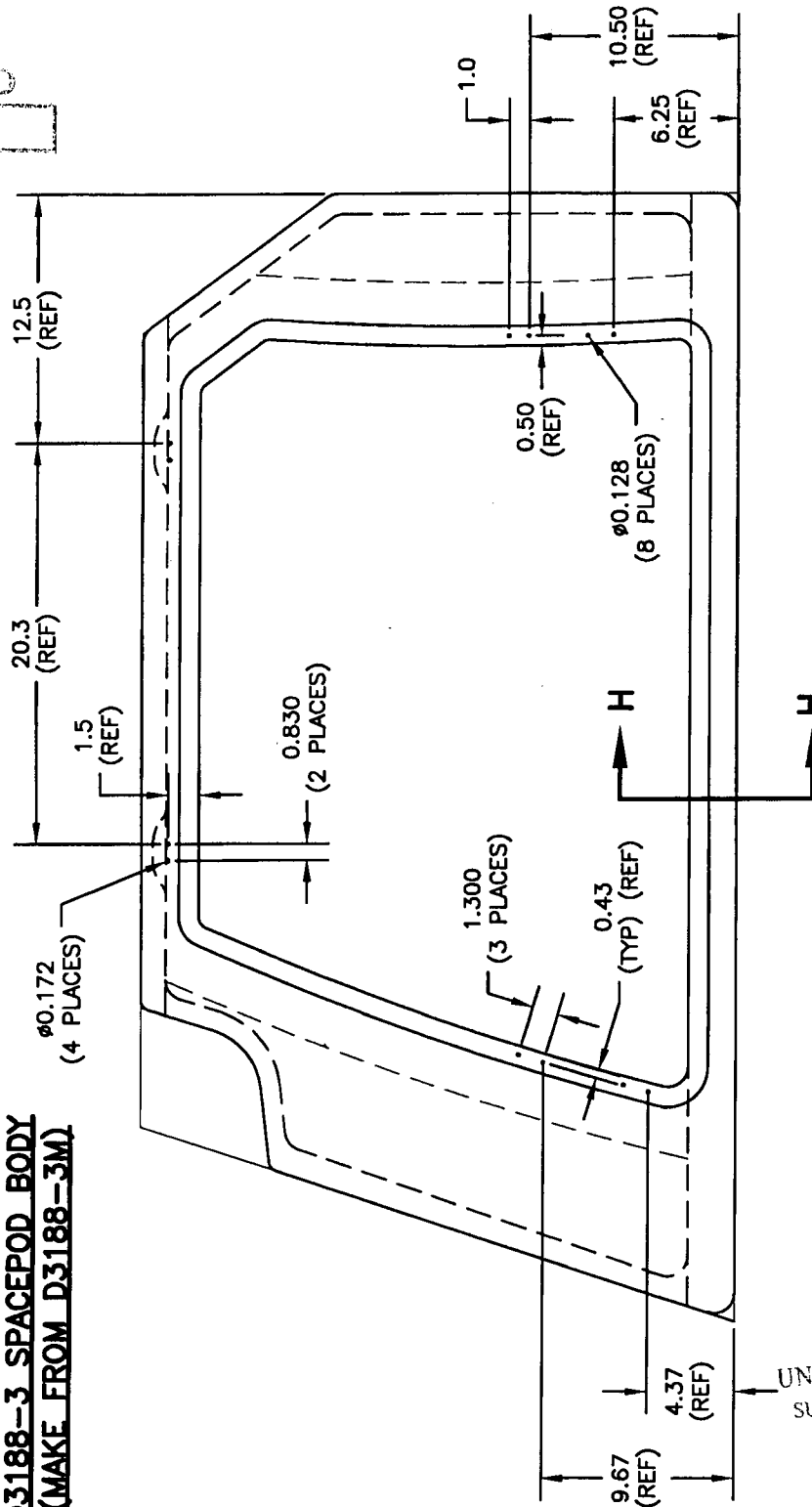
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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07.02.27 H



D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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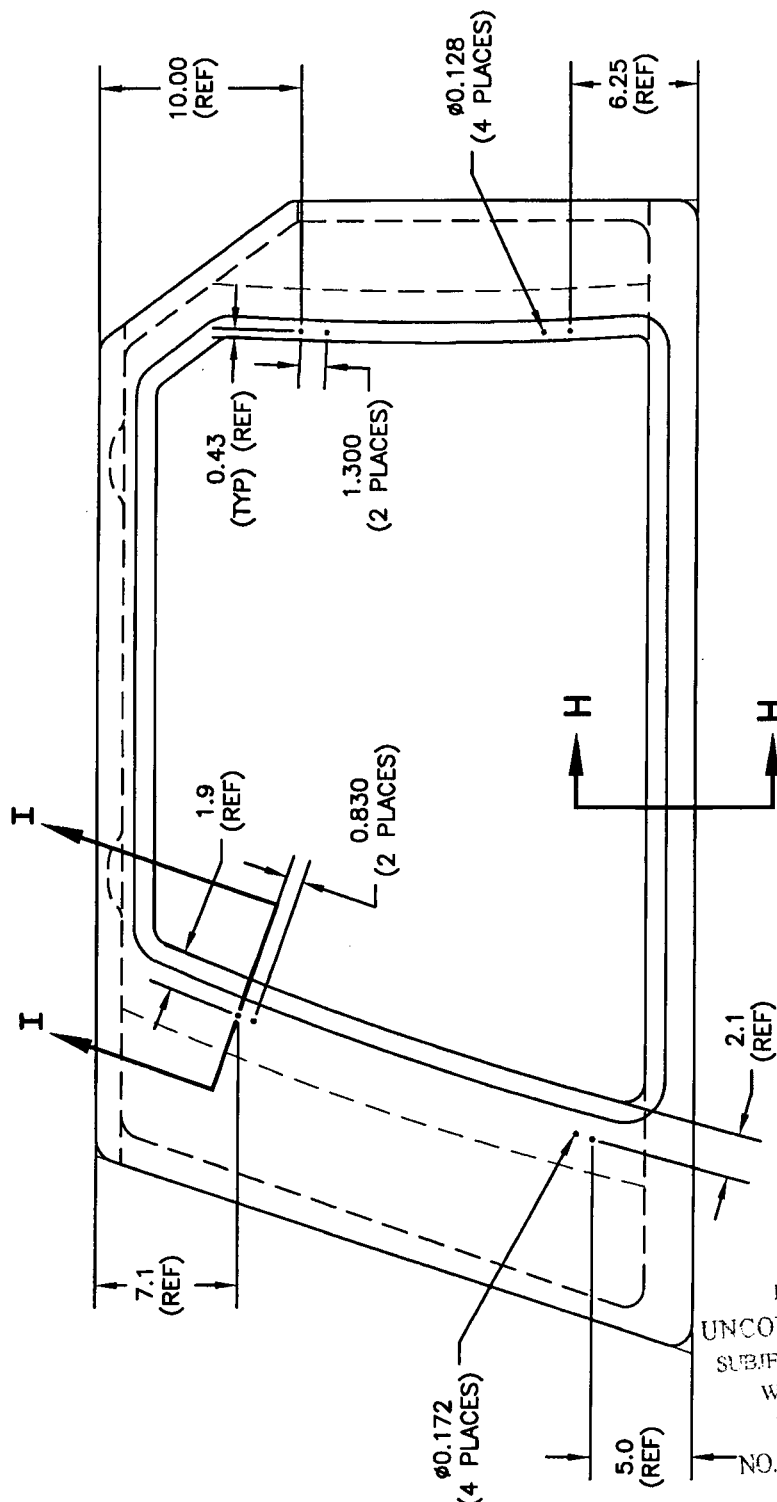
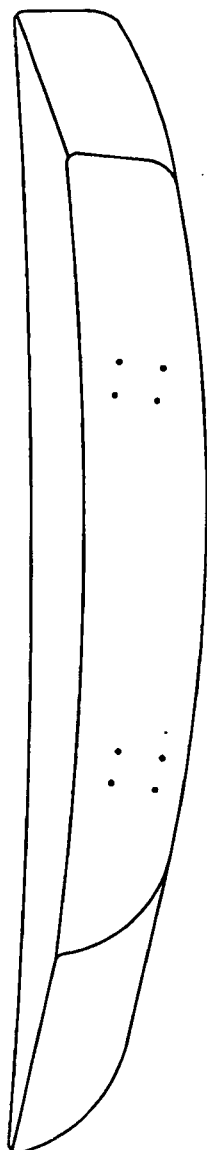
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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07.02.22 [Signature]

**D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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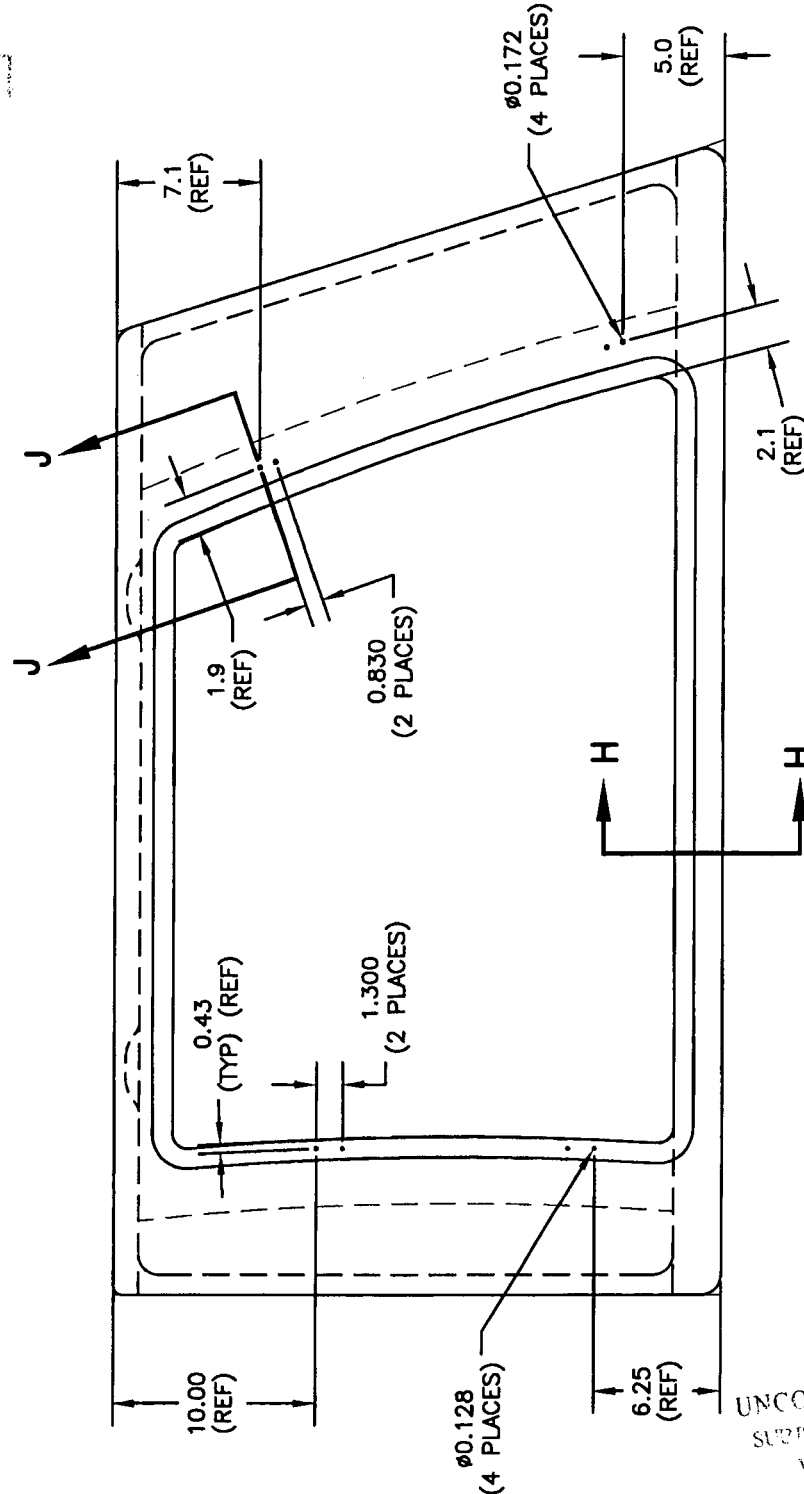
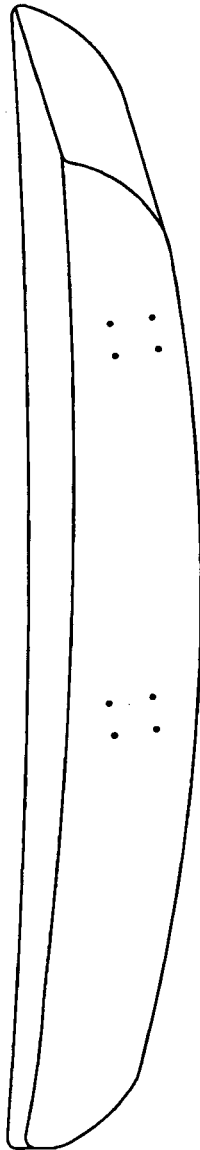
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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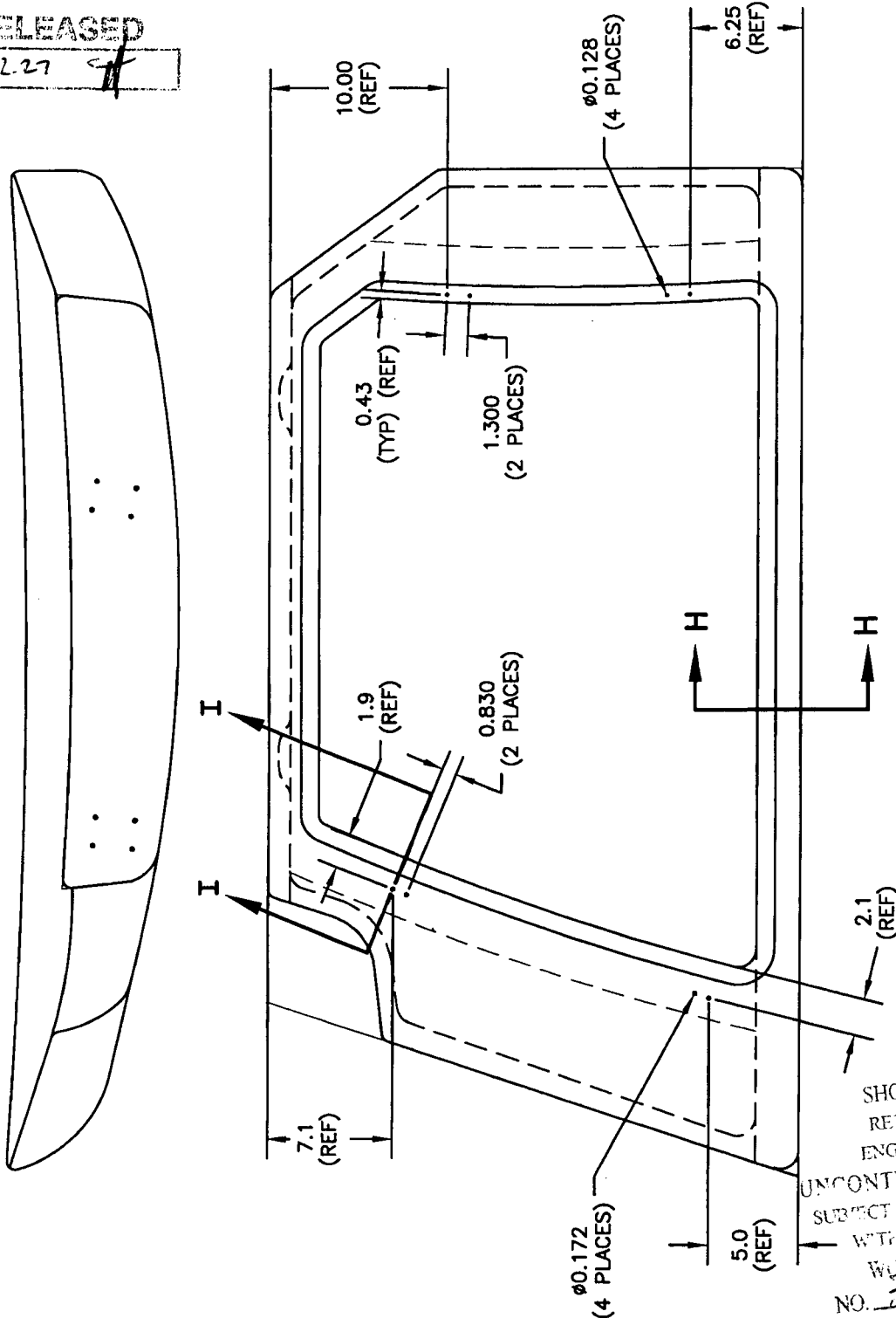
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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



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DATE 07.02.22	TITLE SPACEPOD BODY		SCALE NTS

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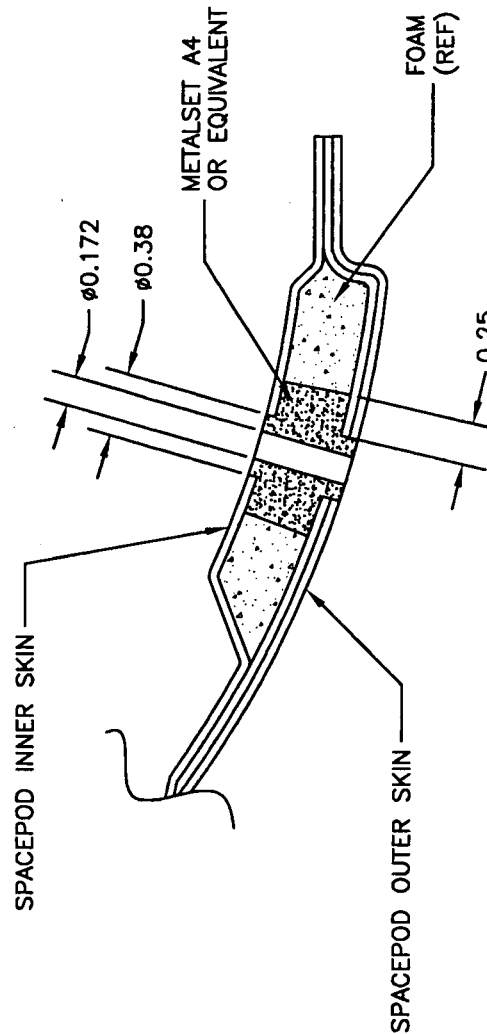
07.02.27 *[Signature]*

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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